

Work Order ID 74208 RH

Tuesday, September 27, 2011 10:44:51 AM



Page 1

Item ID: D206-642-151

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Skidtube

Start Date: 10/3/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 11/4/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: MF

Date: 11-09-27

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

Draw Nbr

Revision Nbr

D3804

A

IIN-D206-642

O

100

0.00



DOCUMENT CONTROL

DC

0.00

Document Control

Memo

Photocopy bluefile & type labels per PPP D206-642-151

CHG001

N/A

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
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Page 2

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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

110

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Deburr Fwd edge of tube

2- Remove ridge on inside of Fwd edge of tube as per Dwg D3804

3-Weld Fwd Cap as per Dwg D3804. Use aluminum rod. Grind D2647 to fit as required.

Pick:

Qty ☐ Part Number ☐ Description ☐ BatchA/R ☐ Aluminum Rod ☐

4-Grind weld flush to cap on top surface only.

5-Cut Aft end as per dwg D3804 from front of tube and Deburr

6-Remove inner indexing ridge on Aft end of skidtube as per Dwg D3804

7-Open holes for Aft end cap as per Dwg D3804 with #30 Drill Bit using DT8025.

8-Drill pilot holes using Dt8166 & DT8169D & DT9771.

9-Locate DT8732 from inner Aft saddle hole & 3rd crossbolt hole. Insert D3286-1 doubler using DT8732 & D206-642-241-T1, then locating doubler off of 3/16" holes, cleco DT8732 & doubler leaving DT8732 for added support.

10- Drill D3286-1 doubler rivet holes in tube using #30 drill, spot drilling doubler at the same time.

SAO 11-10-13

SAO 11-10-14

DC
11/10/18

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Page 3

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Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

11-Working from the center out, drill # 30 holes into D3286-1 doubler. Cleco each hole as it is being drilled. Verify angle of holes to accommodate rivet heads.

12-Remove 3/16" cleco's only and open GHW holes to Ø0.500" as per Dwg D3804

13-Remove D3286-1 doublers, identify orientation, deburr, then attach them to the workorder

14-Remove indexing edge using DT8741 as per Dwg D3804

15-C'sink GHW rivet holes as per Dwg D3804

16- Open Aft cap hole #6.
****no wearplate holes for this skidtube****

17-Deburr tube and blow out chips from inside the tube

DL
11/10/18

SAD 11-10-18

DL 11/10/21

PTO

120



QC

Quality Control

QC6- Inspect dimensions to drawing

0.00

Memo

0.00

DP 11-10-21

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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| | | | | | | | |
| | | | | | | | |

Part No: D206-642-151 PAR #: _____ Fault Category: Landig Gear NCR: Yes ☒ No ☐ DQA: 1 Date: 11/11/18
 Resolution: Re-work Disposition: Re-work QA: N/C Closed: ck Date: 11/11/18

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| 11/10/19 | #10 | When Drill in for Doublet two hubs were elongated P.C. Process (Drill through Al to Stainless this happened) | <i>[Signature]</i> QSP42 | Fill both hubs with weld. as per AS2005 A/R <u>M117884</u> ensure no large build ups on in size of tube. | <i>[Signature]</i> 11/10/20 | <i>[Signature]</i> 11/10/19 | <i>[Signature]</i> QSP42 | <i>[Signature]</i> 11/10/19 |
| | | | | Grind Flush + Re Drill. AS PER Dwg. | <i>[Signature]</i> 11/10/21 | <i>[Signature]</i> 11/10/19 | | <i>[Signature]</i> 11/10/19 |
| | | | | | | | | |

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Page 4

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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140



HandFinish

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

Hand Finishing

DC 11/10/21

150



QC

QC3- Inspect Part Finish

0.00

Memo

0.00

Quality Control

DP 11-10-21

160



Skidtubes

Skidtubes

0.00

Memo

0.00

Skidtubes

1-Open holes to finished size as per Dwg D3804, (without cutting fluid)

2-C'sink crossbolt spacer holes as per Dwg D3804(without cutting fluid)

3-Deburr and blow out all chips from inside the tube

7 DC 11/10/21

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Page 5

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Customer:

Reference:

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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

170

QC6- Inspect dimensions to drawing

0.00

DP

11-10-21



QC

Memo

0.00

Quality Control

180

Skidtubes

0.00



Skidtubes

Memo

0.00

Skidtubes

1-Locate, install and rivet doublers as per Dwg D3804. Micro-shave rivets as required

pc 11/10/21

2-Bond D2654-3 web in place as per QSI 015. Ensure holes line up. Allow 12 Hrs. cure time before cutting

Start Date: ☐ 4/10/21 ☐ Time: ☐ 11:12 ☐

Finish Date: ☐ 4/10/22 ☐ Time: ☐ 10:00 ☐

Pick:

Qty ☐ Part Number ☐ Description ☐ Batch

A/R ☐ Sikaflex-291 ☐ 118393 ☐

Sikaflex expire date: ☐ 12/04/05 ☐

| W/O: | | WORK ORDER CHANGES | | | | | |
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Page 6

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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

1 0 86 11/10/23

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Page 7

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Customer:

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

200

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-remove alodine from around hole and prepare for welding

2-Prep per QSI 005 and Insert D2649 crossbolt spacers. Weld as per QSI 004 and Dwg D3804. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.

Pick:

Qty ☐ Part Number ☐ Description ☐ Batch

A/R ☐ Aluminum Rod ☐ M117884

3-Grind welds flush as per Dwg D3804.

4-Using DT8733, insert (2) D3286-3 spacers as per QSI 004 and Dwg D3804. Remember to back drill each hole to Ø0.402" before welding other side. Use SS rod as required.

A/R ☐ SS Rod ☐ NONE BE 11/10/24

5-Counterbore 5/16" x 0.750" deep except 7th hole from Aft end as per Dwg D3804. Deburr

BE 11/10/22

11/10/24

DP 11-10-24

| W/O: | | WORK ORDER CHANGES | | | | | |
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Page 8

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Stop



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|---|---|----------------------|------------|----------|--------------|---------------|---------------|------------------|----------------|
| 210 HandFinish Hand Finishing | HandFinishing Memo Install D2680-041 Nut Plate as per Dwg D3804 | 0.00 0.00 | | | | | | | |
| | | | DP | 11-10-24 | | | | | |
| 215 QC Quality Control | QC9- Inspect visual per QSI004- Fusion Welds Memo | 0.00 0.00 | | | | | | | |
| | | | 11.10.25 | | | | | | |
| 220 QC Quality Control | QC10- Inspect visual per QSI004- ground welds Memo | 0.00 0.00 | | | | | | | |
| | | | 8/11/10/25 | | | | | | |

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Page 9

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Run Start



Stop



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|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

230 QC5- Inspect part completeness to step on W/O

0.00

S 11/10/15



QC

Memo

0.00

Quality Control

240 Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

IX Ø m-f 11/10/26

250 White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

START TIME:
OVEN TEMPERATURE:
FINISH TIME:

*9:00
320°F
9:30*

IX Ø m-f 11/10/27

117745

| W/O: | | WORK ORDER CHANGES | | | | | |
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Page 10

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Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

260

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

1 RH *φ* *u/u/101*

270

HandFinishing

0.00



HandFinish

Memo

0.00

Hand Finishing

1-Install D2651-3 O-Rings on D2651-1 plugs with Petroleum Jelly and install
✓ plugs as per Dwg D3804. Clean excess adhesive.*1 RH* *φ* *u/u/101*

| W/O: | | WORK ORDER CHANGES | | | | | |
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Page 11

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Run Start



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|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 280 | HandFinishing | 0.00 | | | | | | | |
| HandFinish | Memo | 0.00 | | | | | | | |
| Hand Finishing | 1-Install D2646 Aft Cap and seal with Sikaflex. Clean excess adhesive ✓ A/R <input type="checkbox"/> Sikaflex-291 <input type="checkbox"/> 111944 <input type="checkbox"/> Sikaflex expire date: <input type="checkbox"/> 12/01 | | | | | | | | |
| | 2- Install wearplate as per dwg | | | | | | | | |
| | 2-Wing Walk as per Dwg D3804 and QSI 005 4.4 <input type="checkbox"/> Batch: 1118980 | | | | | | | | |
| 290 | QC3- Inspect Part Finish | 0.00 | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

IRH 4 11/1/11

8 u/u/17

| W/O: | | WORK ORDER CHANGES | | | | | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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| | | | | | | | | |

NOTE: Date & initial all entries

Work Order ID 74208

Tuesday, September 27, 2011 10:44:51 AM



Page 12

Item ID: D206-642-151

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Skidtube

Start Date: 10/3/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 11/4/2011 Req'd Qty: 1.00

Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

300 QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8/11/11

41
BY

310

0.00



Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D206-642-151
Location: _____
PPP Rev: _____

74367

11/11/11

320

0.00



QC

QC21- Final Inspection - Work Order Release

Memo

0.00

Quality Control

11/11/11

ME 11-11-26

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

Tuesday, September 27, 2011 10:44:47 AM

Page 1

Work Order ID: 74208

Parent Item: D206-642-151

Parent Item Name: Replacement Skidtube



Start Date: 10/3/2011

Required Date: 11/4/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 10.12.08 PER IIN REV.N DD VERF:EC
REV:B 11.09.16 PER IIN REV.O DD VERF:EC IPP

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

| | | | | | | | | | | | | | |
|------------------------|--|--------------|----|--|--|-----|------|---------|---|---|--|--|--|
| D2620 | | Manufactured | No | | | 110 | Each | 23.0000 | 1 | 1 | | | |
| | | | | | | | | | | | | | |
| Skidtube, 206 Skidtube | | | | | | | | | | | | | |

Location

Loc Qty

Loc Code

LG

23

B73785

②

71616

5

71617

6

73781

5

73786

3

73787

4

| | | | | | | | | | | | | | |
|-------|--|--------------|----|--|--|-----|------|---------|---|---|--|--|--|
| D2647 | | Manufactured | No | | | 110 | Each | 36.0000 | 1 | 1 | | | |
| | | | | | | | | | | | | | |
| Cap | | | | | | | | | | | | | |

Location

Loc Qty

Loc Code

LG002

36

55352

8

71171

28

B73826

| | | | | | | | | | | | | | |
|--------------|--|-----------|----|--|--|-----|------|-----------|----|----|--|--|--|
| CR3212-4-04 | | Purchased | No | | | 180 | Each | 10,997.00 | 52 | 52 | | | |
| | | | | | | | | | | | | | |
| Cherry Rivet | | | | | | | | | | | | | |

Location

Loc Qty

Loc Code

ST311

997

116471

78

117816

179

118686

1

118840

739

ST516

10000

119017

10000

54

OK 11/10/21

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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NOTE: Date & initial all entries

Picklist Print

Tuesday, September 27, 2011 10:44:47 AM

Page 2

Work Order ID: 74208



Parent Item: D206-642-151



Parent Item Name: Replacement Skidtube

Start Date: 10/3/2011

Required Date: 11/4/2011

Start Qty: 1.00

Required Qty: 1.00

D2654-1 Manufactured No

180 Each

12.0000 1 1



Web

Location

Loc Qty

Loc Code

LG

12

①

73789

73794

10

73790

2

D3286-1 Manufactured No

180 Each

80.0000 2 2



Doubler

Location

Loc Qty

Loc Code

LG002

80

②

64563

6

74111

74

D2649 Manufactured No

200 Each

2,007.000 19 19



Cross Bolt Spacer

Location

Loc Qty

Loc Code

LG

736

68224

2

71355

2

72704

2

72841

130

73855

600

LG001

1271

65317

1

68507

11

73390

59

73857

600

73860

600

19

De 11/10/21

De 11/10/21

De 11/10/22

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Tuesday, September 27, 2011 10:44:47 AM

Page 3

Work Order ID: 74208

Parent Item: D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 10/3/2011

Required Date: 11/4/2011

Start Qty: 1.00

Required Qty: 1.00

D3286-3 Manufactured No

200 Each

98.0000 2 2



Spacer



BE 11/10/24

Location Loc Qty Loc Code

LG001 83

74117 83

2

LG002 15

64564 15

D2680-041 Manufactured No

210 Each

40.0000 1 1



Nut Plate



Location Loc Qty Loc Code

LG 40

73334 40

① DP 11-10-24

CR3212-4-03 Purchased No

210 Each

2,116.000 2 2



Cherry Rivet



Location Loc Qty Loc Code

FP-B 2

110139 2

ST311 1114

114859 1114

ST318 1000

119017 1000

② DP 11-10-24

AN960JD416 NAS1149D0463J Purchased No

210 Each

0.0000 1 1



Washer



M118384

(x1) 11/11/01

Tuesday, September 27, 2011 10:44:47 AM

Shop Packet Print

Page 3

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Tuesday, September 27, 2011 10:44:47 AM

Page 4

Work Order ID: 74208

Parent Item: D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 10/3/2011

Required Date: 11/4/2011

Start Qty: 1.00

Required Qty: 1.00

CCR264SS3-3

Purchased

No

210

Each

1,401.000

2

2



Cherry Rivet

Location

Loc Qty

Loc Code

FP-B

2

113973

2

ST311

399

117086

21

117849

378

ST317

1000

119017

1000

DP 11-10-24

MS27039-4-06

Purchased

No

210

Each

29.0000

1

1



Screw

Location

Loc Qty

Loc Code

FP-A

8

115460

8

ST292

21

115460

21

M119124

xl

D2651-1

Manufactured

No

270

Each

289.0000

6

6



Plug

Location

Loc Qty

Loc Code

fpa

109

69018

109

FP-A

180

57869

1

66445

10

67760

36

70691

100

70839

2

71037

31

B73827

xl

Tuesday, September 27, 2011 10:44:48 AM

Shop Packet Print

Page 4

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Tuesday, September 27, 2011 10:44:48 AM

Work Order ID: 74208



Parent Item: D206-642-151



Parent Item Name: Replacement Skidtube

Start Date: 10/3/2011

Required Date: 11/4/2011

Start Qty: 1.00

Required Qty: 1.00

D2651-3

Manufactured No

270

Each

1,799.000

6

6



O-Ring



xl 11/4/01

LocationLoc QtyLoc Code

FP-A

1799

61962

12

66956

282

73489

505

73828

1000

xl

D3873-1

Manufactured No

280

Each

599.0000

14

14



Bushing



xl 11/4/01

LocationLoc QtyLoc Code

ST084

4

68247

4

ST088

595

64760

1

70690

47

71837

87

73399

60

73829

400

B73831

xl

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Tuesday, September 27, 2011 10:44:48 AM

Page 6

Work Order ID: 74208

Parent Item: D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 10/3/2011

Required Date: 11/4/2011

Start Qty: 1.00

Required Qty: 1.00

D2646

Manufactured No

280 Each

87.0000 1 1



Aft Cap



Handwritten: 10/4/11

Location

Loc Qty

Loc Code

FP004

43

B73294

68280

43

x1

FP006

5

62678

5

FP-4

35

70945

1

71070

34

fp5

4

71038

4

D3805-041

Manufactured No

280 Each

0.0000 1 1



Wearplate Assembly Fwd, Low Gear



B74893 (x1) 10/4/11

MS27039-1-08

Purchased No

280 Each

1,216.000 2 2



10/4/11

Screw

Location

Loc Qty

Loc Code

ST291

1216

115108

16

117423

300

118378

400

118910

500

x2

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

Tuesday, September 27, 2011 10:44:48 AM

Page 7

Work Order ID: 74208

Parent Item: D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 10/3/2011

Required Date: 11/4/2011

Start Qty: 1.00

Required Qty: 1.00

MS21042L3 Purchased No
Nut

280 Each 8,411.000 7 7



Handwritten: ululol

Location Loc Qty Loc Code

ST300 2411
117441 16
117601 240
117885 155
118451 1000
118927 1000
ST516 6000
119017 6000

Handwritten: 77

D3805-045 Manufactured No
Wearplate Assembly Aft, Low Gear

280 Each 6.0000 1 1



Handwritten: 3741895 (v1) ululol

Location Loc Qty Loc Code

FP 6
70878 6

Handwritten: 2

AN960JD10L NAS1149D0332J Purchased No
Washer

280 Each 0.0000 2 2



Handwritten: M117087

Handwritten: (x2) ululol

AN3-37A Purchased No
Bolt

280 Each 261.0000 7 7



Handwritten: ululol

Location Loc Qty Loc Code

ST353 211
111668 111
118628 100
ST354 50
117619 50

Handwritten: 77

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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NOTE: Date & initial all entries

Picklist Print

Tuesday, September 27, 2011 10:44:48 AM

Page 8

Work Order ID: 74208



Parent Item: D206-642-151



Parent Item Name: Replacement Skidtube

Start Date: 10/3/2011

Required Date: 11/4/2011

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0363J

Purchased

No

280

Each

4,404.000

7

7



M 11/4/11

Washer

Location

Loc Qty

Loc Code

ST298

4404

117601

274

118077

1130

118612

1000

118968

2000

x 7

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

| ITEM | Qty -041 | Qty -043 | Part Number | Description |
|------|-------------|-------------|--------------|---------------------------------|
| 1 | X | | D3804-041 | SKIDTUBE ASSEMBLY, 206 A/B LOW |
| 2 | | X | D3804-043 | SKIDTUBE ASSEMBLY, 206 A/B HIGH |
| 5 | 1 | 1 | D2600-1-160 | EXTRUSION |
| 6 | 1 | 1 | D2646 | AFT CAP |
| 7 | 1 | 1 | D2647 | CAP |
| 8 | 19 | 20 | D2649 | CROSS BOLT SPACER |
| 9 | 6 | 8 | D2651-1 | PLUG |
| 10 | 6 | 8 | D2651-3 | O-RING |
| 11 | | 1 | D2654-3 | WEB |
| 12 | 1 | | D2654-1 | WEB |
| 13 | 1 | 1 | D2680-041 | NUT PLATE |
| 14 | 2 | 2 | D3286-1 | DOUBLER |
| 15 | 2 | 2 | D3286-3 | STUD |
| 21 | 2 | 2 | AN960JD10L | WASHER |
| 22 | 1 | 1 | AN960JD416 | WASHER |
| 23 | 2 | 2 | CCR264SS3-3 | RIVET |
| 24 | 2 | 2 | CR3212-4-03 | RIVET |
| 25 | 52 | 52 | CR3212-4-04 | RIVET |
| 26 | 2 | 2 | MS27039-1-08 | SCREW |
| 27 | 1 | 1 | MS27039-4-06 | SCREW |

NOTES

- 1) MATERIAL: N/A
- 2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: 12.5 lb
- 9) WELD PER DART QSI 004
- 10) BENDING: DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 11) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
- 12) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)

#74206

RELEASED
UP 09.03.03
per ECN 09-536

| | | | |
|------------|-------------|--|--------------|
| A | NEW ISSUE | MB | 08.07.07 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | 97 | DART AEROSPACE USA, INC | |
| DRAWN | | PORT HADLOCK, WA | |
| CHECKED | 98 | DRAWING NO. | REV. A |
| MFG. APPR. | 99 | D3804 | SHEET 1 OF 5 |
| APPROVED | 100 | TITLE | SCALE |
| DE APPR. | 101 | SKIDTUBE ASSEMBLY, 206A/B | NTS |
| DATE | 08.07.07 | COPYRIGHT © 2008 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC. | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

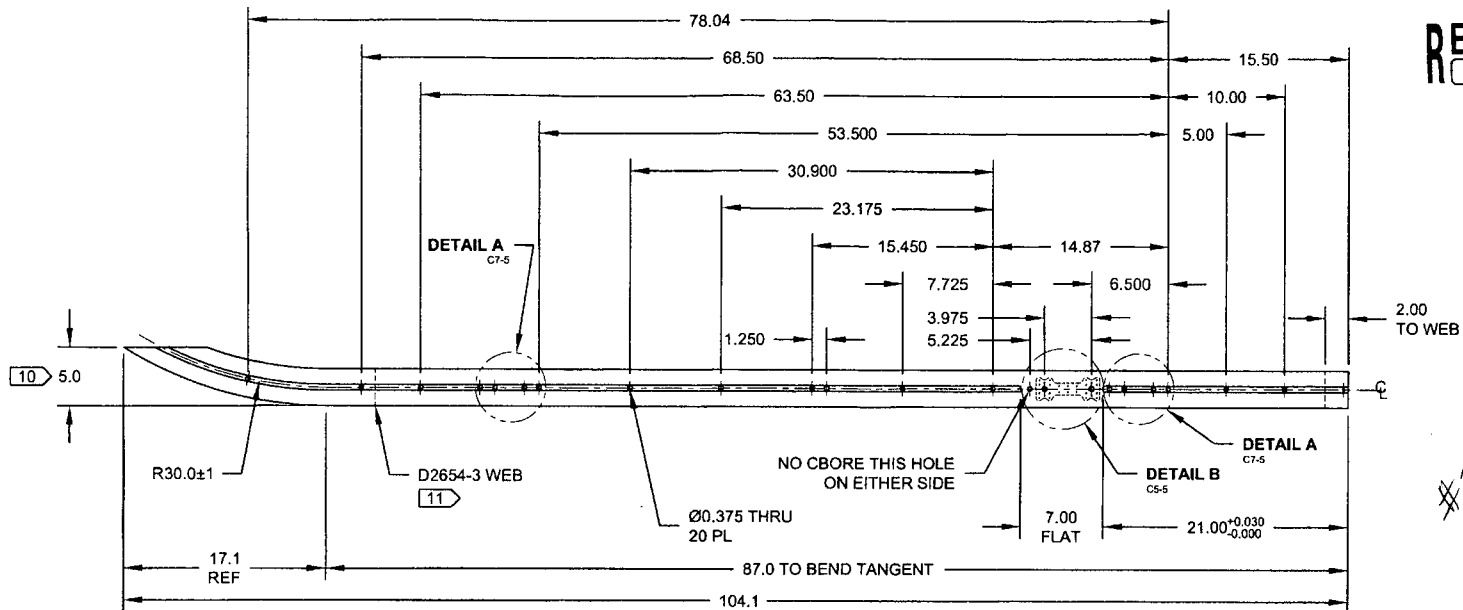
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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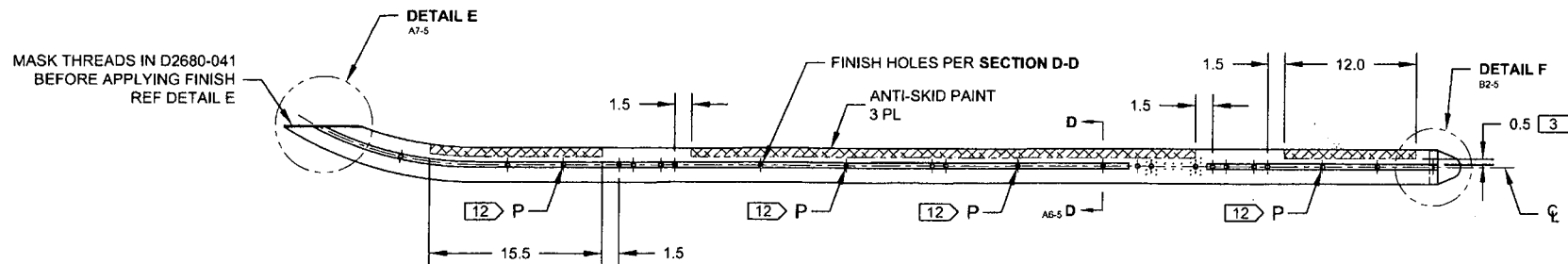
NOTE: Date & initial all entries

RELEASED
09-03-03

#74208



D3804-043 BENDING/DRILLING DETAIL



D3804-043 ASSEMBLY/FINISHING DETAIL

| | | | |
|------------|----------|---|--------|
| DESIGN | 97 | DART AEROSPACE USA, INC | |
| DRAWN | 97 | PORT HADLOCK, WA | |
| CHECKED | 97 | DRAWING NO. D3804 | REV. A |
| MFG. APPR. | 97 | SHEET 3 OF 5 | |
| APPROVED | 97 | TITLE | SCALE |
| DE APPR. | 97 | SKIDTUBE ASSEMBLY, 206A/B | NTS |
| DATE | 08.07.07 | <small>COPYRIGHT © 2008 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small> | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

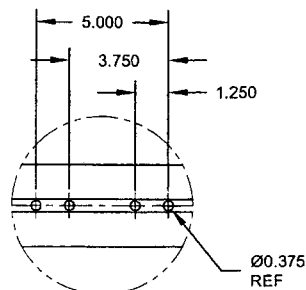
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

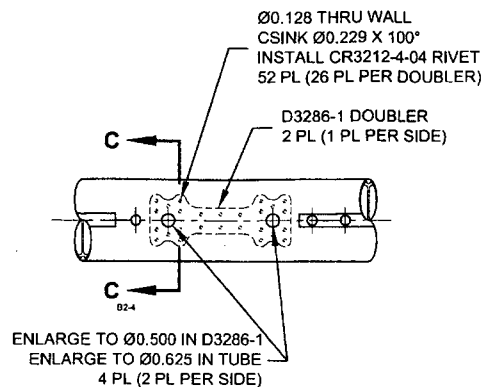
| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

RELEASED
UP 09.03.07



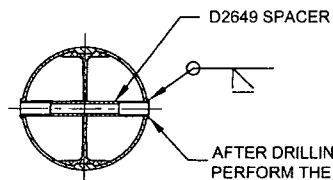
DETAIL A D6-2
SCALE NONE C2-2
D6-3
C2-3



DETAIL B C3-2
SCALE NONE C3-3

- TO INSTALL D3286-1/3:
1. GRIND OFF FLANGE IN AREA SHOWN, FLUSH WITH OUTSIDE SURFACE OF ROUND TUBE
 2. LOCATE & DRILL D3286-1 DOUBLER USING DT3286-1T1
 3. ENLARGE HOLES IN D3286-1 TO Ø0.500
 4. ENLARGE HOLES IN TUBE TO Ø0.625 AND CHAMFER HOLE 0.03 X 45°
 5. RIVET D3286-1 TO TUBE
 6. INSERT D3286-3 SPACER
 7. WELD IN PLACE AND GRIND FLUSH

SECTION C-C C6-4
PARTIAL SECTION
SCALE NONE



SECTION D-D A4-2
FOR Ø0.375 HOLES ONLY A4-3
SCALE NONE

| | | | |
|------------|----------|--|--------|
| DESIGN | 91 | DART AEROSPACE USA, INC | |
| DRAWN | 91 | PORT HADLOCK, WA | |
| CHECKED | 91 | DRAWING NO. D3804 | REV. A |
| MFG. APPR. | 91 | SHEET 4 OF 5 | |
| APPROVED | 91 | TITLE | SCALE |
| DE APPR. | 91 | SKIDTUBE ASSEMBLY, 206A/B | NTS |
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| W/O: | | WORK ORDER CHANGES | | | | | |
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| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

RELEASED
97 09.03.03

#74208

CCR264SS3-3
RIVET
2 PL

CR3212-4-03 RIVET
2 PL

VIEW G-G
SCALE NONE A7-5

MS27039-4-06 SCREW
AN960JD416 WASHER
D2680-041
NUTPLATE

D2647 CAP, TO INSTALL:
1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D2647 (TRIM AS REQD)
4. WELD D2647 IN PLACE
5. GRIND FLUSH
6. RIVET D2680-041 NUT PLATE
IN PLACE

1.0 REMOVE RIDGE ON
INSIDE OF SKIDTUBE
LEAVE 0.070 MIN.

1/16

DETAIL E
SCALE NONE B7-2
B7-3

0.400

END OF WEB

BORE OUT END
OF SKIDTUBE
TO 0.75 DEPTH
AND 0.070 WALL

SEAL WITH
SIKAFLEX-241/291

D2646 AFT CAP

Ø0.204
REF

MS27039-1-08 SCREW
AN960JD10L WASHER
2 PL

DETAIL F
SCALE NONE B2-2
B2-3

| | | | |
|------------|----------|--|--------------|
| DESIGN | 97 | DART AEROSPACE USA, INC | |
| DRAWN | 97 | PORT HADLOCK, WA | |
| CHECKED | 97 | DRAWING NO. | REV. A |
| MFG. APPR. | 97 | D3804 | SHEET 5 OF 5 |
| APPROVED | 97 | TITLE | SCALE |
| DE APPR. | 97 | SKIDTUBE ASSEMBLY, 206A/B | NTS |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

NO. 273

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 74236
Part number: D206 642 151
Description: 206 skid tube
Welding Process: Tig ☒ Mig ☐
Base material: Aluminum
Current: AC ☒ DC ☐

TEST REQUIREMENTS AND RESULTS

Visual: pass ☒ fail ☐
Penetration: pass ☒ fail ☐

UNACCEPTABLE

Cracks: pass ☒ fail ☐
Undercut: pass ☒ fail ☐
Pin holes: pass ☒ fail ☐
Overlap (cold lap): pass ☒ fail ☐
Porosity (surface): pass ☒ fail ☐
Coloration: pass ☒ fail ☐

Qualifier Sally Lunn Date of Test Coupon 11-10-25

Welder Barclay Elliott Date of Test Coupon 11-10-25

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

